Claims:

1. In a luggage case having at least one outer shell, the shell in turn having a generally broad face, this broad face formed of a fabric panel, the improvement comprising an injection molded frame attached to an edge of the fabric panel, and an autogenously formed bond between the frame and the fabric panel.

2. In the luggage case of claim 1 wherein the shell has a series of walls upstanding from the broad face, the injection molded frame integrally forming the series of upstanding walls.

3. In the luggage case of claim 2 wherein the upstanding series of walls consist of a back wall, a front wall, and side walls extending between the front wall and the back wall.

4. In the luggage case of claim 3 wherein the back wall includes integrally formed hinge knuckles for hingedly attaching the shell to the rest of the luggage case.

5. In the luggage case of claim 2 wherein the front wall includes at least one latching device for selectively holding the shell to the rest of the luggage case.

6. In the luggage case of claim 1 wherein the panel further includes a layer of textile fabric and a layer of a foam polymer to stiffen the textile fabric layer.

7. In the luggage case of claim 1 wherein the bond between the frame and fabric panel extends around substantially the entire periphery of the panel.

8. In the luggage case of claim 6 wherein the fabric and the foam layer are laminated to one another to form a laminated panel, the perimeter of the panel having a peripheral edge portion upstanding from the major dimension of the panel, the extreme edge of the edge portion having a cut edge, the cut edge being hidden

by the injection molded frame attached thereto.

9. In the luggage case of claim 7 wherein the panel has a thickness dimension perpendicular to the major dimension and generally equal to the thickness of the fabric and the foam layer, but the thickness of the extreme edge thereof being substantially less than the thickness dimension.

10. In the luggage case of claim 2 wherein the frame further includes a thick section adjacent the series of walls, the thick section including the autogenous bond.

11. A process of forming a shell of a luggage case from a laminated panel having a peripheral edge portion, and made of a foam panel layer and a fabric covering and an injection molded frame, comprising the steps of positioning the peripheral edge portion inside an injection mold for forming the frame, and injecting plastic material into the mold to form an autogenous bond between the plastic material and the edge portion.

12. A process of forming a shell of a luggage case as set forth in claim 11 wherein the step of positioning includes holding the edge portion against an inside surface of an injection mold for forming the frame, and injecting fluid plastic into the mold while maintaining the peripheral edge portion against the inside surface of the mold.

13. A process of forming a shell of a luggage case as set forth in Claim 12 wherein the inside surface of the mold is a surface that forms an inside surface of the finished shell.

14. A process of forming a shell of a luggage case as set forth in Claim 12 including leading the plastic material to a portion of the mold adjacent to the peripheral edge portion before substantially filling the mold with plastic material, whereby the plastic material adjacent the peripheral edge portion helps to maintain the peripheral edge portion against the inside surface of the mold.

15. A process of forming a shell of a luggage case as set forth in claim 14 further including supplying a mold cavity having a portion thereof sized to create relatively thin web portions of the frame, and a thick portion immediately adjacent to the peripheral edge portion, and introducing the plastic material into the mold cavity at the thick portion, whereby the plastic material preferentially fills the thick portion prior to filling the remainder of the mold cavity.

16. A process of forming a shell of a luggage case as set forth in claim 15 further including the step of introducing into the thick portion a second fluid along with the plastic material, whereby a hollow section is formed in the thick portion of the completed shell.

17. A process of forming a shell of a luggage case as set forth in claim 16 wherein the second fluid is a gas.

18 A process of forming a shell of a luggage case as set forth in claim 16 wherein the second fluid is a blowing agent.